

## ABSTRACT

### **METHOD OF ASSEMBLING A HARD DISK DRIVE HAVING A MOTOR BRACKET TOOLING HOLE FOR INVERTED MOTOR-TO-BASE MERGE PROCESS**

**[0028]** A method of enabling a reliable, motor-to-base merge process is designed for motors that are attached to a base with screws that mount from outside of the base. An assembly fixture receives the motor, which has a tooling hole for circumferentially locating the motor relative to the base. The assembly fixture closely receives the motor and has a tooling pin that engages the tooling hole to prevent rotation of the motor relative to the assembly fixture. During the motor-to-base merge process, the motor is inverted with the tooling pin in the tooling hole. The assembly fixture aligns the threaded screw holes in the motor with the mounting holes on the base.